Work Ord April-11-13 2:		653		*996	353*	,	*.				Page 1	eteranter tu
Item ID: Revision ID: Item Name:	D4093-1 Bracket			Accept	*N900	<u>040</u>	100)* s	etup Sta	1.71	S1* S2*	* Paradase*
Start Date: Required Date Reference:	4/11/13 :: 4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	ID:	ŗ	. *				
Approvals:	Process Pla	an:	Date: <i>13-04</i>	Tooling: SPC (Y/N):		ate:	-	F	Run Sta Sto	VI q	R1* R2*	
Sequence ID/ Work Center l	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr										
D4093 110 *110* Waterjet FLOW CNC Water		Memo CUT AS DV DWG REV: PROG REV ***HOLES ****DEBU	WILL BE MADE ON N	0.00 0.00 MILLING***				8			<i>I</i> mB	-06-28
120 *120* QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				8	0	·	Jm13-	g-20

										DQA:	Date	e:•
NCR: Y	es / No				WORK ORDER NON-	COI	VFORM	MANCE / UP	DATE	QA Closed:	Date	e:
Work Orde	r:				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
Part N NCR N	0				Rework Skid-tube Crosstube Water Jet E Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging Supplier Supplier				Engineering Quality Other			
Root				Descr	iption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data			<u>.</u>									
quip/Tooling	_											
perator	_											
Material	_											
etup Other	-											
rocess												
upplier	-											
raining												
Inapproved												
				<u> </u>		FAUI	LT CATE	GORY				
Landir	ng Gear				General						_	
	Bendin	3			Bend		Grain			Ovalized	ļ	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed	d/Crimped	l. :		Burrs	_	-	tions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		Maintenance Part Moved					
1	Heat Tr	•			Countersink	Mislabeled Positioned Wrong						
ļ	 1	on Strip ir	i Tube	<u>_</u>	Cut Too Short	Misread Power Loss/Surge Other				Other		
		in Bend		L	Drill Holes	_	Offset		के तहें हों.			
1	Torque Waves in Extrusion Drawing					┥	Calibration					
ľ	Turning	Turning Sequence Finish Out of Sequence										

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 99653 April-11-13 2:33:20 PM				*996	553*				Page	2
Item ID: Revision ID: Item Name:	D4093-1 Bracket			Accept	*N900040	100³	Setu	p Start Stop	*NS1*	
Start Date: Required Date: Reference:	4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:				IV.72	
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II 130 *130* Mill Conv Conventional Millin		Operation Description Memo DRILL AND	O C'SINK AS PER DWG	Set Up/ Run Hours 0.00	Tool ID Tool#		-		Reject Insp. Number Stamp	
132 *132* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00 A	73-07-17		8	ø		
135 *135* QC		QC8- Inspect parts - seco	and check	o.oo _{o.oo}	-a 13/07/18	_	8	φ_	0As 08	

Quality Control

										DQA:	Date	e:
NCR: Yes	s / No				WORK ORDER NON-C	CON	FORN	1ANCE / UP	DATE	QA Closed:	Date	•:
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	· · · · · · · · · · · · · · · · · · ·
Part No	Part No. NCR No.				Rework Scrap Use-as-is Work Order Update		Machining Small Fa Thermoforming Finishir		Crosstube Small Fab Finishing Composite	Prod. Eng. Coong Rec/Store/Packagin		Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	itial ef Eng		ction cription	Sign & Date	Verification	QC Inspector
quip/Tooling perator Material etup Other rocess upplier iraining												
		· · · · · · · · · · · · · · · · · · ·		·		AULT	CATEC	3ORY				
Landing	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in	-	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			on Incomplete ions Incomplete, nance · led	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Torque Waves in Extrusion Drawing Turning Sequence Finish			-	Out of Calibration Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord April-11-13 2:		9653		*996	353*				Page 3
Item ID: Revision ID: Item Name:	D4093-1 Bracket		u. 200 0 - 222 - 2 20 - 7	Accept	*N90004)* Setu	p Start Stop	14.71
Start Date: Required Date Reference:	4/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:				14(1)
Approvals:		Jan:					Run	Start Stop	"NRT"
Sequence ID/ Work Center	ID	Operation Description Chemical Conversion Co	pat ner OSI005 4 1	Set Up/ Run Hours	Tool ID Too	ol # Plan Code			Reject Insp. Number Stamp
140 HandFinish Hand Finishing		Memo	34 pt. Q 01003 1.1	0.00			8	Bi	3712
160 *160* QC Quality Control		QC7-Inspect Chemical C	Conversion Coat	0.00	1-33 1		8		
170 *170* Packaging Packaging		Identify as per dwg & St Memo	tock Location.	0.00			-8X	oden a e /	37-

...

								,	DQA:	Date:	
NCR: Y	'es	/ No		4	 WORK ORDER NON-O	CON	NFORN	MANCE / UPDATE	QA Closed:	Date:	
Work Orde	· r·			>	DISPOSITION			AGAINST	DEPARTME N T,	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging					
Root Cause		Date	Step	Qty	ption of work order update or Non-conformance	1	nitial ief Eng	Action Description	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier fraining											
						AUL	T CATE	GORY			
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped t n Strip in Bend Yaves in I	Tube Extrusio	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misrea Offset Out of	ion Incomplete tions Incomplete/Unclear enance eled	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned Power Loss	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw			Folio	Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

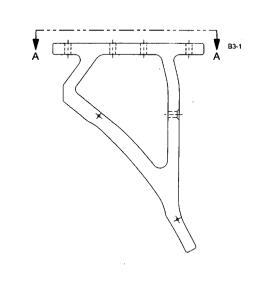
DART AEROSPACE LTD	Work Order:	99663
Description: Bracket	Ad 24.77 Part Number:	D4093-1
	1 13.0	
Inspection Dwg: D4093 Rev		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

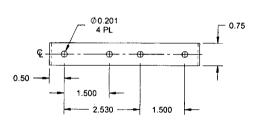
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.92	+/-0.030	0,92" 3.855	-		V	Jamos
3.85	+/-0.030	3.855	_		V	
4.03	+/-0.030	4.032	_		7	
5.03	+/-0.010	5.021	_		V	
0.36	+/-0.010	0.351"			V	
0.76	+/-0.030	0.76"	-		V	
4.82	+/-0.030	4.82	-		V	
0.38	+/-0.030	0.365	-		V	
4.20	+/-0.030	4.20	_		V	
7.03	+/-0.030	7.03"	1		ν	
0.750	+/-0.010	0.752"	_		V	
Ø .080	+,005/000					
	,					
	-					
					····	
						·
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Measured by: Jm	Audited by:	Preliminary Approval:
Date: 13-06-28	Date: 18-07-17	Date:

Rev	Date	Change	Revised by A	Approved
Α	11.10.13	New Issue	KJ %	
			7)	



99453 pl/3-04-14



SECTION VIEW A-A D6-1



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С

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4117/4128/4115/4116)
OR AGNET B211 OR ASTM B221
OR 6061-T6762 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC, M6061T6B/M6061T6S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.55 lbs

D4093-1 BRACKET

_								
D	ADD Ø	0.080 HOLES	(ZN B5-2, B5-4)	RF	12.09.18			
С	REDRA	WN D4093-1/- (ZN A8-1, A8-	RF	11.07.27				
В	REDRA	WN D4093-1/-	3 (ZN 84-1, B4-2)	RF	11.01.31			
Α	NEW IS	SUE	RF	10.09.16				
REV.			DESCRIPTION	BY	DATE			
DESIGN	٧	RF	DART AEROSPAC	DART AEROSPACE USA, INC.				
DRAW	٧	RF		KENT, WA				
CHECK	ED	A	DRAWING NO.	TNE.				
MFG. A	PPR.	AV	□ D4093		SHEET 1 OF 5			
APPROVED			TITLE	TITLE SCA				
DE APPR.			BRACKET	BRACKET NTS				
DATE	12.0	9.18	COPYRIGHT © 2010 BY DART I					

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R0.38

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R0.38

R0.20

R0.20

R0.29

R0.25

R1.50

R0.25

R1.50

R1.4.0

R14.0

R14.0

R0.38

R0.20

R0.25

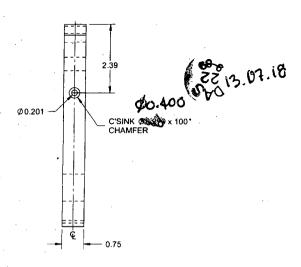
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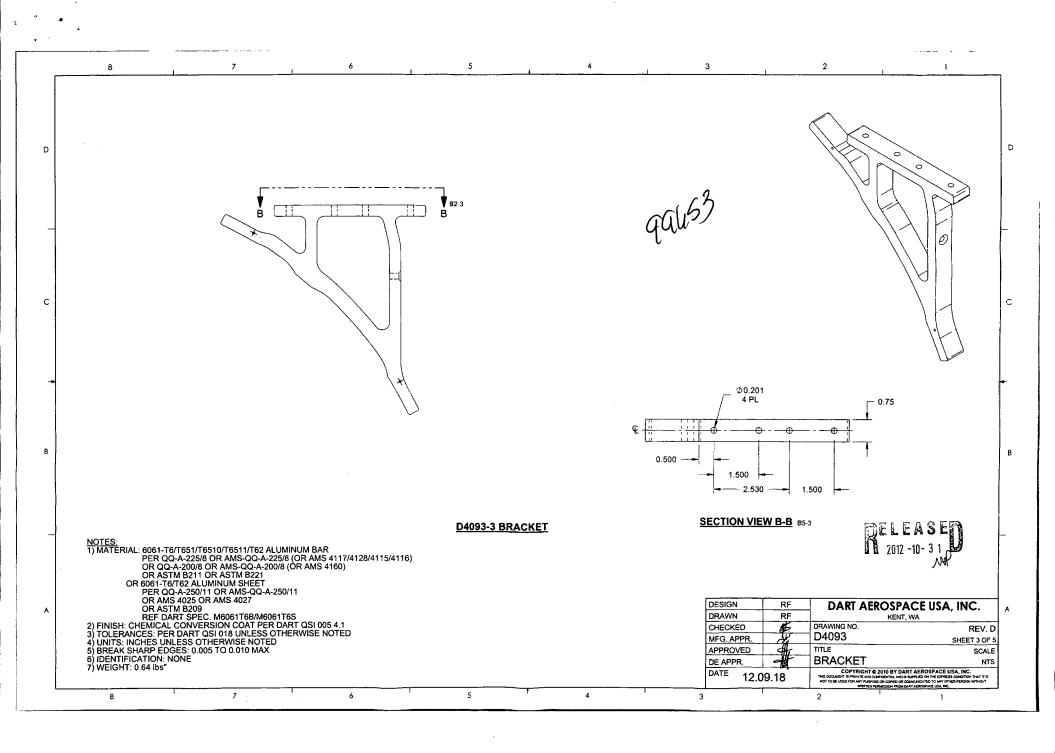
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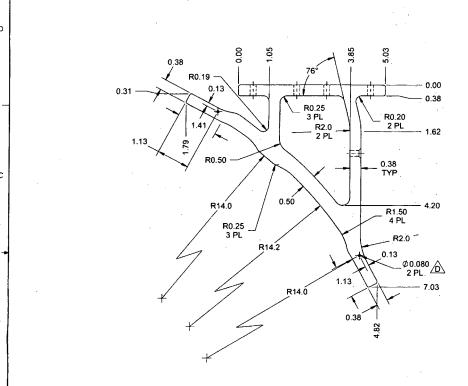


D4093-1 BRACKET

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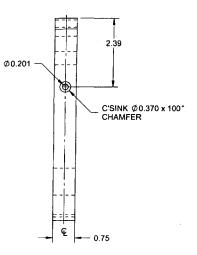
			•				
DESIGN	RF	DART AEROSPACE USA, INC.					
DRAWN	RF						
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MFG. APPR.	W.	D4093	SHEET 2 OF 5				
APPROVED	41	TITLE	SCALE				
DE APPR.	4	BRACKET	NTS				
DATE 12.0	9 18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS REVAITS AND COMPONENTAL AND IS EXPRESS ON THE COMPACTO COMPONENT TO BE USED FOR MAIN PREVIOUS OF COMPANY COMPONENT TO ANY COMPONENT PERSON WITHOUT					





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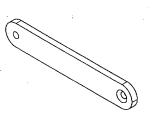


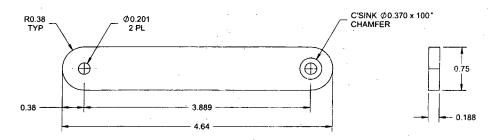


D4093-3 BRACKET



DESIGN .	RF	DART AEROSPACE USA, INC.		
DRAWN	RF			
CHECKED	3 5	DRAWING NO.	REV. D	
MFG. APPR.	A.F.	D4093	SHEET 4 OF 5	
APPROVED	de	TITLE	SCALE	
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DATE 12.	09.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS OCCUMENT IS PROVIDED THAT IT IS NOT TO BE USED TO AN IMPORT OF THAT IT IS NOT TO BE USED TO AN IMPORTOR OF COMED OF COMMUNICATION OF AN INTERESON WITHOUT.		





D4093-5 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4117/4128/4115/4116) OR ASTM B211 OR ASTM B221 OR 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS-4025 OR AMS-4025 OR ASTM B209 OR ASTM B209 REF DART SPEC. M6061T6B/M6061T6S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: NONE 7) WEIGHT: 0.06 lbs

DESIGN	RF	DART AEROSPACE USA, INC.			
DRAWN	RF				
CHECKED	45.	DRAWING NO.	REV. D		
MFG. APPR.	A.	D4093	SHEET 5 OF 5		
APPROVED	all.	TITLE	SCALE		
DE APPR.		BRACKET	NTS		
DATE 12.0	9.18	COPYRIGHT © 2010 BY DART. THIS DOCUMENT IS PRINTE AND CONFIDENTIAL AND IS BUS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COME	PLEO ON THE EXPRESS CONDITION THAT IT IS		

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DART AEROSPACE LTD	Work Order:	99653
Description: Brack &T	Part Number:	4093-1
Inspection Dwg: 4093 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
,500	±.010	, 498			-RAVOM	RAZE
1.500	±.010	1.503			11	9
2.530	±.010	2.525	(11	in
1.500	生.010	1.502			١	ч
0.201	+ . 004	1200	-		٠t	L
, 13	± .030	./00			Vem	RAPL
1.13	±.030	1.120			Vem	ધ
1.58	\$.030	1,570			Sim	4
9.080	4.004	, 1984	-		Venn	RAZL
2.39	±,030	2.380			31006	Height brage
,37×100°	±030 1/0	-380×100°			Varn	RAZU
200×1000	T.010	,410			Ven	RAZL
·						

Measured by:	(A)	Audited by:	b.a	OAS	Preliminary Approval:	
Date:	3-07-17	Date:	13/07/1	မြန်မ	Date:	

Rev	Date	Change	Revised by	Approved
Ε	10.04.14	Added preliminary approval	KJ	